

Work Order ID 131910

Tuesday, April 21, 2015 1:56:23 PM

131910

Page 1

Item ID: D3619-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Grommet
 Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3619	Rev A

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 28245 Purchase Part Number: 9610K17 Supplier: MC
 MASTER CARR Certificate of conformity is required
CL 15/04/23 (4)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure material certification is attached
4x Sp 15-04-24

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control
(4) DAS
38
9-89
APR 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Item ID: D3619-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Grommet
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				4		DAS 06 9-89	
130	Memo	0.00							
Packaging	****Remove supplier paperwork from box.***** Identify and StockLocation: <u>ST052</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	0.00							
QC									
Quality Control									

27
APR 22 2015

MLJ 15-04-27

MLJ 15-04-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

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131910

D3619-1

Required Date: 4/20/15

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-04-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
9610K17		Purchased	No			110	Each	0.0000	1	4			
9610K17									**	4x SP 15-04-24.			
GROMMET													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

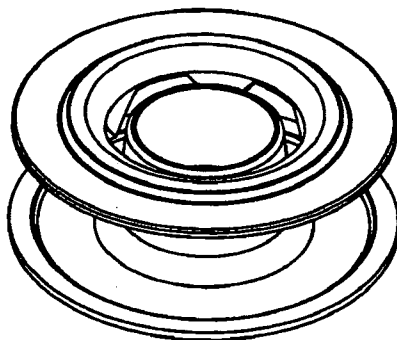
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3619	REV. A SHEET 1 OF 1
DATE 07.03.26		TITLE GROMMET SCALE NTS	
REV A	DATE 07.03.26	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
07 04 02 *[Signature]*

D3619-X GROMMET,
WHERE X REPRESENTS THE GROMMET TRADE SIZE

DART P/N	TRADE SIZE	DESCRIPTION	HOLE SIZE	MAX. MTL THICKNESS	MCMaster CARR P/N
D3619-0	0	BRASS GROMMET W/ TEETH	1/4	0.110	9610K16
D3619-1	1	BRASS GROMMET W/ TEETH	9/32	0.120	9610K17
D3619-2	2	BRASS GROMMET W/ TEETH	3/8	0.150	9610K18
D3619-3	3	BRASS GROMMET W/ TEETH	7/16	0.230	9610K19
D3619-4	4	BRASS GROMMET W/ TEETH	1/2	0.300	9610K21

NOTES:

1) PURCHASE INFO: MCMaster-CARR P/N'S INCLUDE THE FOLLOWING:

48 GROMMETS FOR SIZE 0 & 1,
24 GROMMETS FOR SIZE 2, 3 & 4,
D3619-XT1 HOLE PUNCH,
D3619-XT2 STRIKER BLOCK,
D3619-XT3 PUNCH AND
D3619-XT4 DIE

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

1504-22
131910.MC
COPY
1504-22

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28245**

Purchase Order Date 4/23/2015

PO Print Date 4/23/2015

Page Number 1 of 3

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	9610K17. AS PER DWG D3619 REV. A B131910	GROMMET	4/24/2015 Yes 4/24/2015		4.00 Each	\$12.90	\$51.60
Line Total:							\$51.60
2	63215K52 AS PER DWG D3965 REV. B B131946	Bearing Spherical	4/24/2015 Yes 4/24/2015		10.00 Each	\$15.62	\$156.20
Line Total:							\$156.20
3	71400-45	6264K72HALF LINK	4/24/2015 Yes 4/24/2015		2.00 Each	\$7.80	\$15.60

Note:

4/23/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Jessi

Purchase Order
PO28245

Order Placed By
Chantal Lavoie

McMaster-Carr Number
2485646-01

Page 1 of 1

04/23/2015

Line	Product	Ordered	Shipped
1	9610K17 MIL Spec. Two-Piece Grommet Kit, Trade Size 1, 0.687" OD, 48 Grommets with Teeth Washers Your Part Number: B131910	4 Each	4 ✓
2	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick Your Part Number: B131946	10 Each	10 ✓
3	6264K72 ANSI #40-Stainless Steel Add-and-Connect Link for 304 Stainless Steel, Highly Corrosion-Resistant Roller Chain Your Part Number: 71400-45	2 Each	2 ✓
4	60355K42 Steel Ball Bearing--ABEC-1, Double Shielded, No. R3 for 3/16" Shaft Diameter, 1/2" OD Your Part Number: 71725-45	2 Each	2 ✓
5	7196K31 Straight-Blade, Three-Blade Male Plug, NEMA 5-15 Your Part Number: 71725-45	4 Each	4
6	7494T85 Shop-Vac Vacuum Accessory, 2-1/2" Diameter X 3" Plastic Round Brush Your Part Number: 72000-45	1 Each	1 ✓
7	4719A438 Sanding Sleeve, Multipurpose, 120 Grit, 3/4" Inside Diameter, 1" Long, Packs of 25 Your Part Number: 71500-11	8 Packs	8 ✓

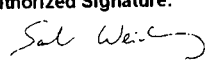
Sp 15 at 34.

McMaster-Carr Supply Company 200 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-Mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 28481919 Purchase Order: PO28245 Release: McMaster-Carr Number: 2485646-01		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 23-Apr-2015		FOB: ORIGIN	
		Shipper's Export Declaration (SED): NO EEI 30.36			
Intermediate Consignee:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada			
		Tax Number:			
Forwarding Agent:		Billing Attention: Shipping Jessi Attention: Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	9610K17 MIL Spec. Two-Piece Grommet Kit, Trade Size 1, 0.687" OD, 48 Grommets with Teeth Washers B131910 Country of Origin: United States Schedule B #: 820559 ECCN #: EAR99 NLR	4 EA	\$12.90	\$51.60
2	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick B131946 Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	10 EA	\$15.62	\$156.20
3	6264K72 ANSI #40-Stainless Steel Add-and-Connect Link for 304 Stainless Steel, Highly Corrosion-Resistant Roller Chain 71400-45 Country of Origin: Japan Schedule B #: 731519 ECCN #: EAR99 NLR	2 EA	\$7.80	\$15.60
4	60355K42 Steel Ball Bearing--ABEC-1, Double Shielded, No. R3 for 3/16" Shaft Diameter, 1/2" OD 71725-45 Country of Origin: Japan Schedule B #: 848210 ECCN #: 1C999 NLR	2 EA	\$6.56	\$13.12

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 3		Number of Packages: 1		Invoice Amounts:		Merchandise Amount: \$345.34	
Package Dimensions: 31 X 31 X 32 CM = .032 CUBIC M				Total (In USD): \$345.34			
				Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days			
Authorized Signature: 		Date: 23-Apr-2015		Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA		(by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg		Title: Operations Mgr.		Page 1 of 2			